



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4436-043
Job Sheet 178141



Part No: D4436-043

Job Qty: 8 ea

Part Name: Aft Outboard Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/27/18

Job Tracking No:

Due Date: 6/8/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A SHEETS 2,4,5 IPP revA 11.10.06 new issue EC verified by:DD IPP REV:B 12.01.24 PER DWG REV.A DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	6/8/18	6/8/18	0.00	0.00	Start Up Waterjet		SC 8/09/18
100	Waterjet	8 pcs	6/8/18	6/8/18	0.00	1.21	Waterjet1		SC 8/05/18
110	QC	8 pcs	6/8/18	6/8/18	0.00	0.00	QC2 Waterjet-3		SC 8/05/18
120	QC	8 pcs	6/8/18	6/8/18	0.00	0.00	QC8-4		38
130	Brake NC	8 pcs	6/8/18	6/8/18	0.06	0.70	Brake NC 2		9-88 SN
140	Small Fab	8 pcs	6/8/18	6/8/18	0.00	0.93	Small Fab-6		DAS
150	QC	8 pcs	6/8/18	6/8/18	0.00	0.00	QC5		38
160	HandFinish	8 pcs	6/8/18	6/8/18	0.00	0.91	HandFinish1		BFB 18-06-20
170	QC	8 pcs	6/8/18	6/8/18	0.00	0.00	QC7-3		38
180	Small Fab	8 pcs	6/8/18	6/8/18	0.00	0.93	Small Fab-6		DAS
185	QC	8 pcs	6/8/18	6/8/18	0.00	0.00	QC5		38
190	Powdercoat	8 pcs	6/8/18	6/8/18	0.00	0.39	Powdercoat4		BK/15-000
200	QC	8 pcs	6/8/18	6/8/18	0.00	0.00	QC3		Smb
202	Small Fab	8 pcs	6/8/18	6/8/18	0.00	0.93	Small Fab-6		Smb DAS
205	QC	8 pcs	6/8/18	6/8/18	0.00	0.00	QC5		38
210	Packaging	8 pcs	6/8/18	6/8/18	0.00	0.00	Packaging3-2	5/621	DAS 21
220	QC21-SA	8 Ea	6/8/18	6/8/18	0.00	0.00	QC21		9-88

JUN 21 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	12.7200 sf (1.59 ea)	90-Start up Operation	50682015
MS20426AD3-2	Rivet	32 Ea (4 ea)	180-Small Fab	5018535
MS21075L08	Anchor Nut	16 Ea (2 ea)	180-Small Fab	5050045
D4441-1	Rubber Seal	11.2640 ft (1.408 ea)	202-Small Fab	151347

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.040	13	239	0
180-Small Fab	MS20426AD3-2	32	384	0
	MS21075L08	16	230	0
202-Small Fab	D4441-1	11	70	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date : _____	Step #: _____	QTY Effective : _____
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Description Work Order Deviation

42) Approval _____

ated By _____

Supervisor _____

ification _____

inator _____

DART
AEROSPACE

Container No: S077433

Part: D436-043

Job No: 178141

Serial No/Batch: S077433

Revision: _____

Inspector: _____

Exp. Date: 06/03/2018

Instructions: _____

Date: 08/03/18

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Newbury, ON K5A 1K7
CANADA
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Email: sales@dartaero.com
www.dartaero.com

Root Cause							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐		
Design	☐	Operator	☐	Bending	☐		
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentr	☐		
Equip/Tooling	☐	Supplier	☐	Cracks	☐		
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/W	☐		
Material	☐	Use for Testing	☐	Cuffs	☐		
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐				
Misidentified	☐	Past Due	☐	OTHER :			

Part Specifications

Specifications could not be found.

Plex 5/28/18 7:32 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

DART AEROSPACE LTD		Work Order:	178141
Description: A7 out board bracket Assembly		Part Number:	D4436-043
Inspection Dwg: D4436	Rev: A	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/- 0.030	0.754	1		ISC-01	
1.55	+/- 0.030	1.555	1		Tap	
1.73	+/- 0.030	1.732	1			
3.16	+/- 0.030	3.165	1			
0.01201	+0.006/-0.001	0.01202	1			
16.68	+/- 0.030	16.681	1			
16.97	+/- 0.030	16.975	1			
17.58	+/- 0.030	17.588	1			
1.83	+/- 0.030	1.834	1			
5.18	+/- 0.030	5.187	1			
5.22	+/- 0.030	5.223	1			
17.47	+/- 0.030	17.477	1			
0.850	+/- 0.010	0.853	1			
1.10	+/- 0.030	1.105	1			
2.04	+/- 0.030	2.046	1			
4.89	+/- 0.030	4.90	1			
5.02	+/- 0.030	5.022	1			
6.42	+/- 0.030	6.425	1			
10.02	+/- 0.030	10.026	1			
10.79	+/- 0.030	10.794	1			
11.54	+/- 0.030	11.548	1			
0.650	+/- 0.010	0.651	1			
0.0177	+0.005/-0.001	0.0177	1			
0.0198	+0.004/-0.001	0.0199	1			
0.468	+/- 0.010	0.470	1			
0.234	+/- 0.010	0.235	1			
4.70	+/- 0.030	4.701	1			
3.77	+/- 0.030	3.777	1			
4.70	+/- 0.030	4.702	1			

Measured by: SC	Checked by: DAS 38	QC Inspector:
Date: 18/05/31	Date: JUN 06 2018	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					